

# Work Order ID 64793

Friday, December 17, 2010 7:55:47 AM



Page 1

Item ID: D3294-1

Accept



Setup Start



Revision ID:

Item Name: Bracket

Stop



Start Date: 12/16/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 1/19/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan:

*PL*

Date:

*10/27*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3294

Rev C

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3294

Cut File D3294-3

Dwg Rev: *C*

Prog Rev: *C*

*2824 . 080*

\*grain direction on a 45 deg as per dwg\*\*

2-Deburr if necessary

*B 11-2-8*

*8*

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

*B 11-2-8*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_






NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



**NOTE:** Date & initial all entries






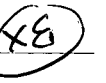
# Work Order ID 64793

Friday, December 17, 2010 7:55:47 AM

Page 2

Item ID: D3294-1	Accept		Setup	Start	
Revisor ID:					
Item Name: Bracket				Stop	
Start Date: 12/16/2010	Start Qty: 8.00		Cust Item ID:		
Required Date: 1/19/2011	Req'd Qty: 8.00		Customer:		
Reference:					

Approvals:	Process Plan: _____	Date: _____	Tooling: _____	Date: _____	Run	Start	
	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00 0.00		8 u102/08					
130  Brake NC Brake NC	Memo 1-Deburr if necessary 2-Bend as per Dwg D3294 (Ensure angle is correct)	0.00 0.00		SB 11/02/10					
140  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00		8 u102/11					

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

[illegible]

Page 3

**Accept**

**Setup Start**

[REDACTED]

**Stop**

[illegible][illegible]**Cust Item ID:**

**Customer:**

Run Start

**Abstract**

**Stop**

**10**

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

### Operation Description

### Set Up/ Run Hours

Tool ID	Tool #	Plan Code
---------	--------	-----------

Accept Qty	Reject Qty	Reject Number	Insp. Stamp

Chemical Conversion Coat per QSI005 4.1

0.00

[illegible]

HandFinish

## Memo

0.00

## Hand Finishing

### QC3- Inspect Part Finish

0.00

**Abstract**

QC

## Memo

0.00

## Quality Control

## Memo

0.00



### Small Fab

### Small Fab

1-Install D3294-5 doubler to D3294-3 bracket with rivets as per dwg. D3294

8/5/02/15 (8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Friday, December 17, 2010 7:55:47 AM



Page 4

Item ID: D3294-1	Accept		Setup Start	
Revision ID:			Stop	
Item Name: Bracket				
Start Date: 12/16/2010	Start Qty: 8.00		Cust Item ID:	
Required Date: 1/19/2011	Req'd Qty: 8.00		Customer:	
Reference:				

Approvals:	Process Plan: _____	Date: _____	Tooling: _____	Date: _____	Run Start	
	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00		<i>Eulorlus</i>		<i>(X8)</i>			
190  Powdercoat Powder Coating	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 <i>M112589</i> Memo Start Time: <i>10:45 AM</i> Oven Temperature: <i>320° F</i> Finish Time: <i>11:45 AM</i>	0.00 0.00				<i>8</i>	<i>8</i>	<i>all 11/02/10</i>	
200  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00 0.00				<i>8</i>	<i>8</i>	<i>11 02 10</i>	<i>(X8)</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 5

Item ID: D3294-1	Accept		Setup Start	
Revision ID:			Stop	
Item Name: Bracket				
Start Date: 12/16/2010	Start Qty: 8.00		Cust Item ID:	
Required Date: 1/19/2011	Req'd Qty: 8.00		Customer:	
Reference:				

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run Start	
	QC:	Date:	SPC (Y/N):	Date:	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	Identify as per dwg & Stock Location: <u>2/2</u>	0.00							
	Packaging								
	Memo	0.00							
	Packaging								
220	QC21- Final Inspection - Work Order Release	0.00							
	QC								
	Memo	0.00							
	Quality Control								

11/2/16 SD

11/02/17

PL 11-02-17  
(8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Friday, December 17, 2010 7:55:52 AM

Page 1

Work Order ID: 64793

Parent Item: D3294-1

Parent Item Name: Bracket



Start Date: 12/15/2010

Required Date: 1/19/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP ☐ A ☐ 04.08.24 ☐ New issue ☐ KJ/JLM ☐  
 IPP Rev:B Now On Waterjet 07-03-26 JLM  
 IPP Rev:C 08-07-16 Redesign part DD verified by:EC  
 IPP Rev:D 08-10-06 revB as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.080  2024-T3 .080 sheet		Purchased	No			100	sf	88.0000	1.8	15.15789			

Location

Loc Qty

Loc Code

MAT22

88

104921

2

105411

7

112331

3

113796

9.7

114025

66.3

116604

8

D3294-5



Doubler

Manufactured

No

170

Each

17.0000

1

8

Location

Loc Qty

Loc Code

WA

17

55331

17

8

MS20470AD4-5



Rivet, Universal Head

Purchased

No

170

Each

1,612.000

15

120

Location

Loc Qty

Loc Code

ST309

112

114761

112

ST319

1500

116410

1500

120

8/11/12/15

8/11/12/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 44793
<b>Description:</b> Bracket Assembly		<b>Part Number:</b> D3294-1
<b>Inspection Dwg:</b> D3294	<b>Rev:</b> C	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	.131	✓		V ISO2	
Ø0.141	+0.005/-0.001	.142	✓		V	
6.708	+/-0.010	6.706	✓		V	
1.118	+/-0.010	1.116	✓		V	
5.590	+/-0.010	5.592	✓		V	
1.118	+/-0.010	1.117	✓		V	
13.563	+/-0.010	13.563	✓		T ISO1	
1.043	+/-0.010	1.043	✓		V	
0.625	+/-0.010	.624	✓		V	
0.325	+/-0.010	.324	✓		V	
0.300	+/-0.010	.299	✓		V	
0.400	+/-0.010	.396	✓		V	
6.000	+/-0.010	5.998	✓		T	
1.000	+/-0.010	.999	✓		V	
17.124	+/-0.010	17.125	✓		T	
16.13	+/-0.030	16.13	✓		T	
7.27	+/-0.030	7.278	✓		V	
11.97	+/-0.030	11.97	✓		T	
8.37	+/-0.030	8.372	✓		PROWS ISO2	
20.05	+/-0.030	20.05	✓		T	
12.98	+/-0.030	12.98	✓		T	
14.59	+/-0.030	14.59	✓		T	
11.66	+/-0.030	11.66	✓		T	
0.080	+/-0.010	.082	✓		V	

<b>Measured by:</b> B
<b>Date:</b> 11-2-8

<b>Audited by:</b> S
<b>Date:</b> 11/02/06

<b>Prototype Approval:</b> N/A
<b>Date:</b> N/A

Rev	Date	Change	Revised by	Approved
A	04.08.24	New Issue	KJ/JLM	
B	06.03.09	Dimension 12.97 was 13.03	KJ/JLM	
C	08.11.27	Dimensions updated per Dwg Rev B	KJ/EC	
D	09.07.29	Dimension 2.100 was 2.072	KJ	
E	09.09.14	Dimensions updated per Dwg Rev C	KJ	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

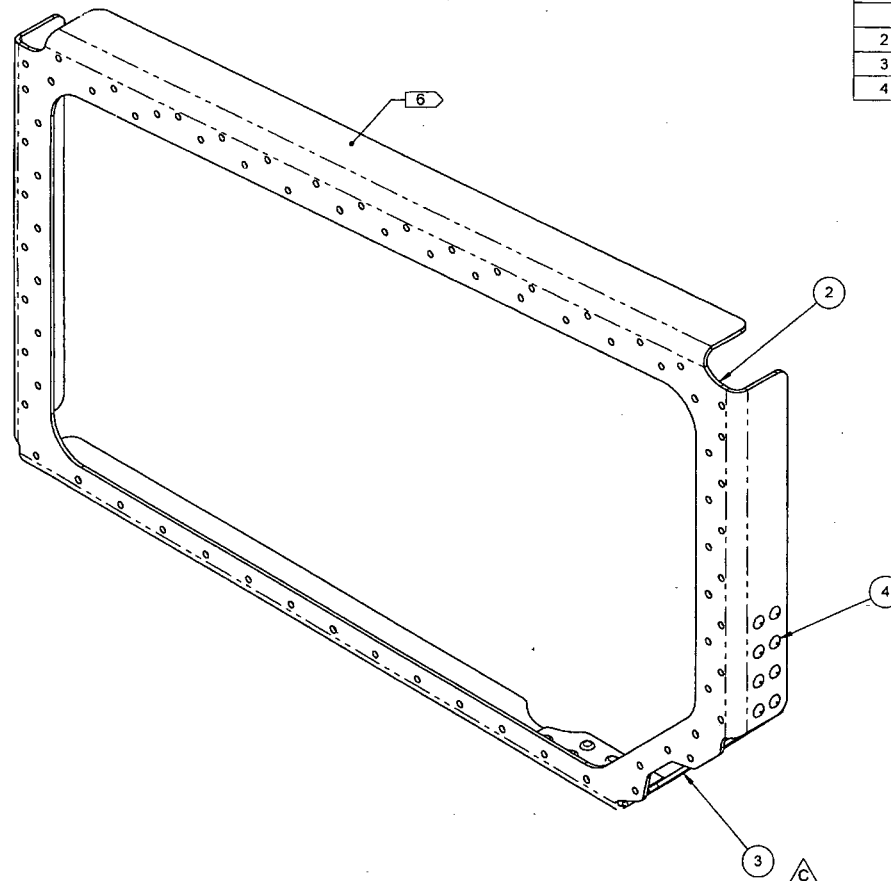
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

ITEM NO.	QTY. -1	PART NUMBER	DESCRIPTION
1	X	D3294-1	BRACKET ASSEMBLY
2	1	D3294-3	BRACKET
3	1	D3294-5	DOUBLER
4	15	MS20470AD4-5	RIVET



**D3294-1 BRACKET ASSEMBLY**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "BLACK" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3294-1 AND B/N" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.83 lbs

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 44793

*28-0-12-17*

**RELEASED**  
*09/07/17*

C	REMOVE FLANGE PREVIOUSLY ADDED. ADD -5 DOUBLER ZN A4-1, SHEET 5+6.	HS	09.03.24
B	CHANGE FLANGE FROM OUTSIDE TO INSIDE, ZN B4-1, C3-2. CHANGE GRAIN DIRECTION, ZN C4-2	HS	08.09.22
A	NEW ISSUE	CP	04.05.28
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>[Signature]</i>		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3294	SHEET 1 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BRACKET	NTS
DATE	09.03.24	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMPILED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

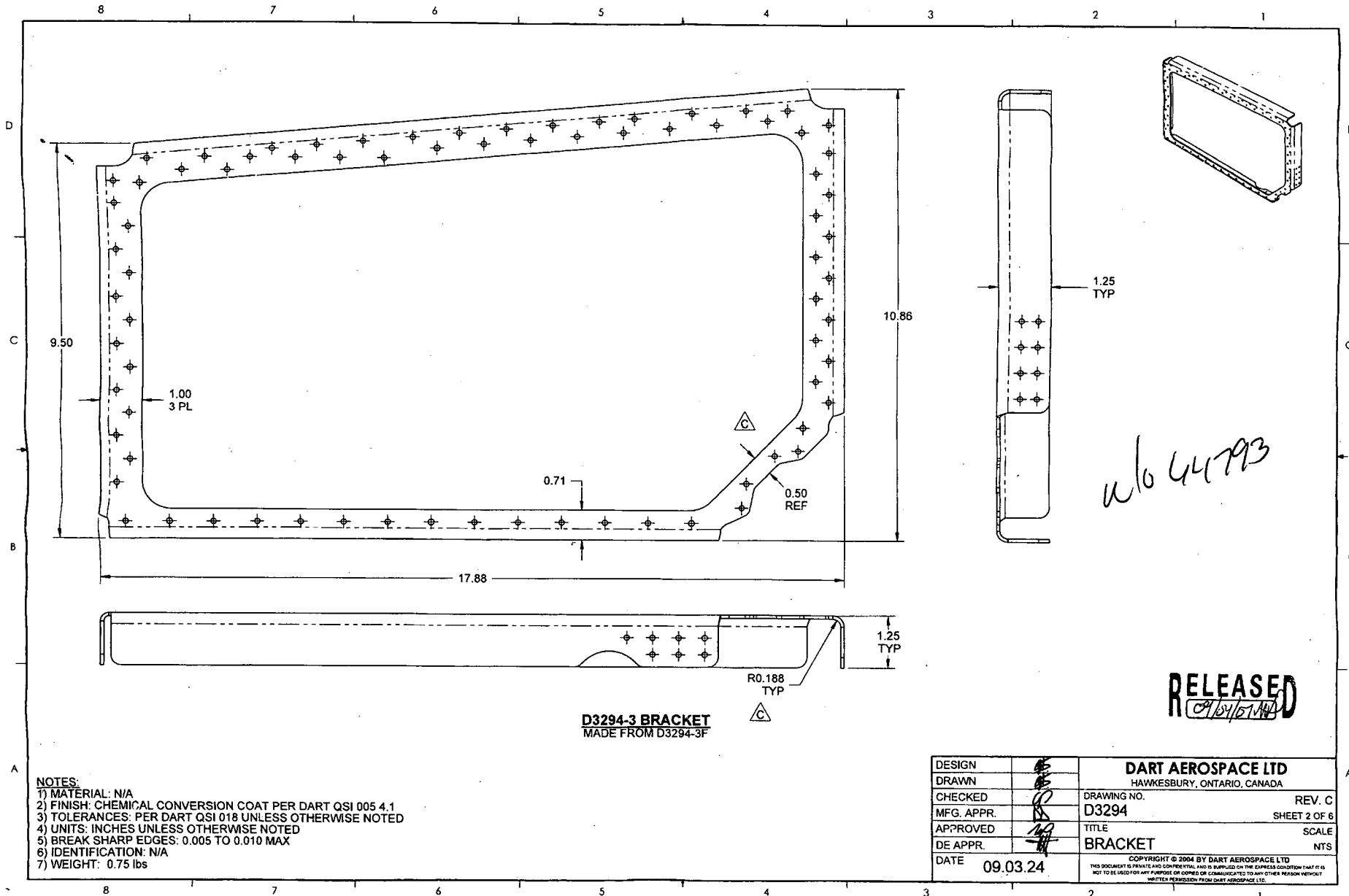
W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



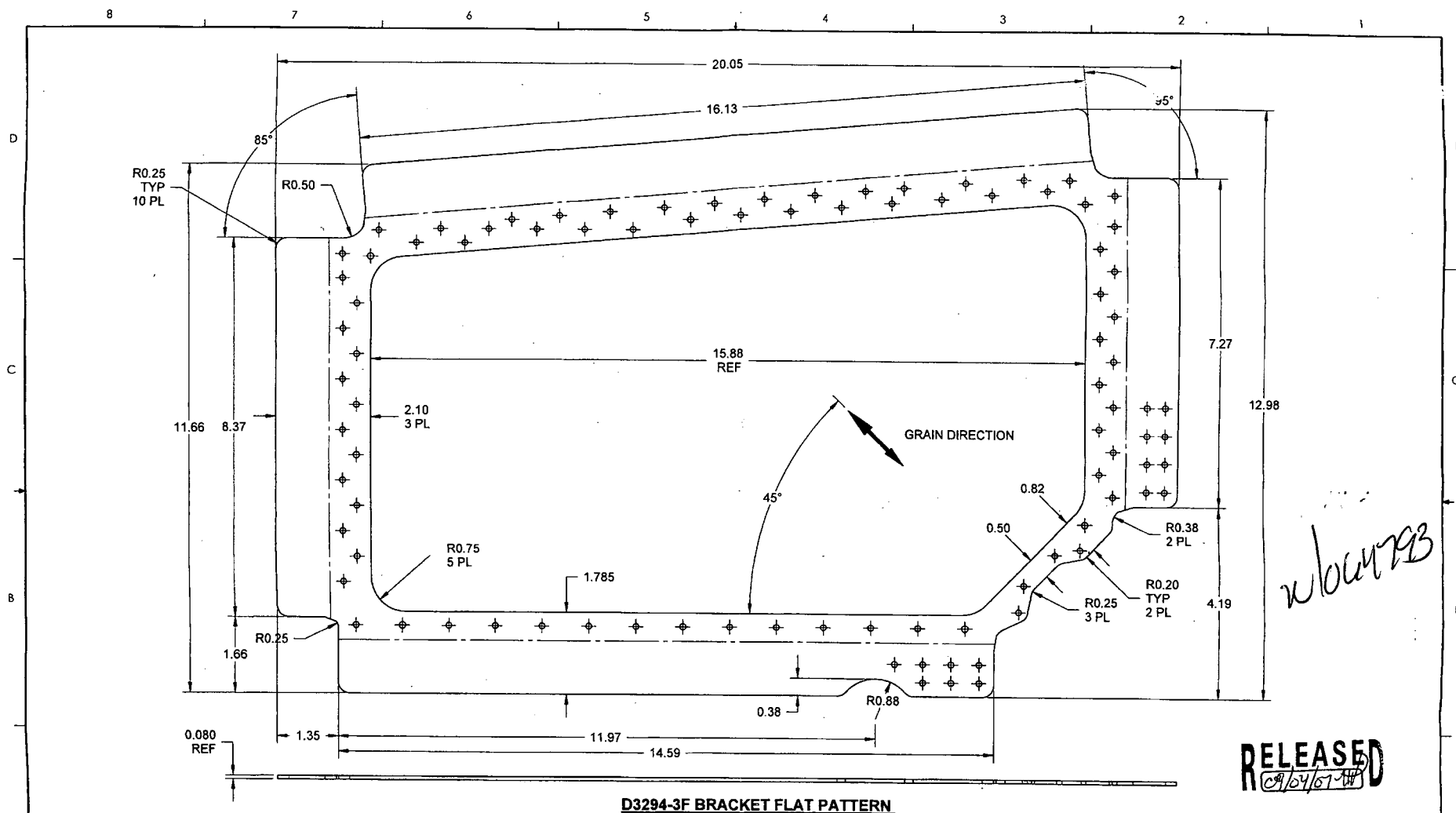
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**NOTE:** Date & initial all entries



**RELEASED**  
09/04/07

**NOTES:**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.080 THICK PER AMS-QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.080)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.75 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3294	SHEET 3 OF 6
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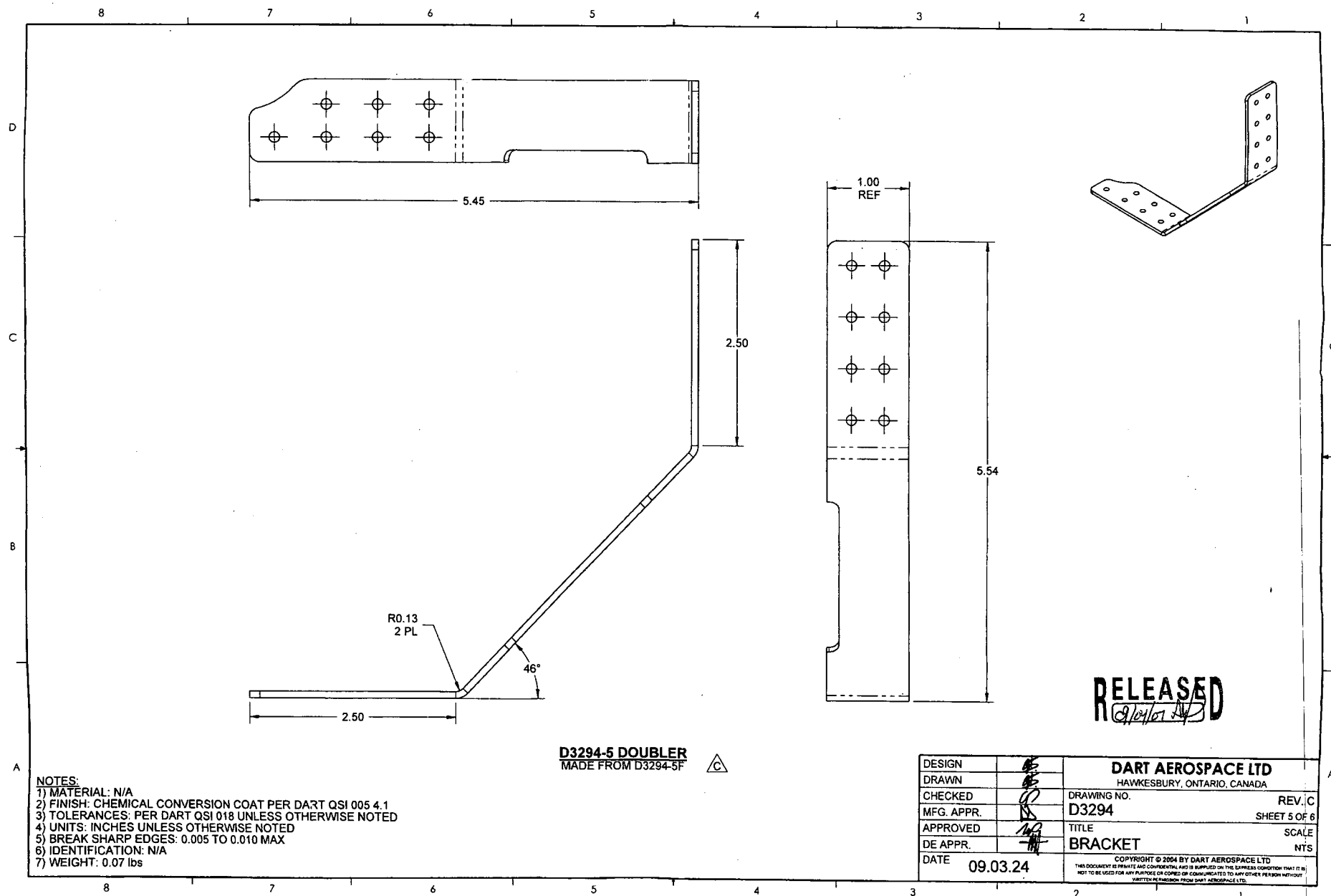
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.07 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3294	SHEET 5 OF 6
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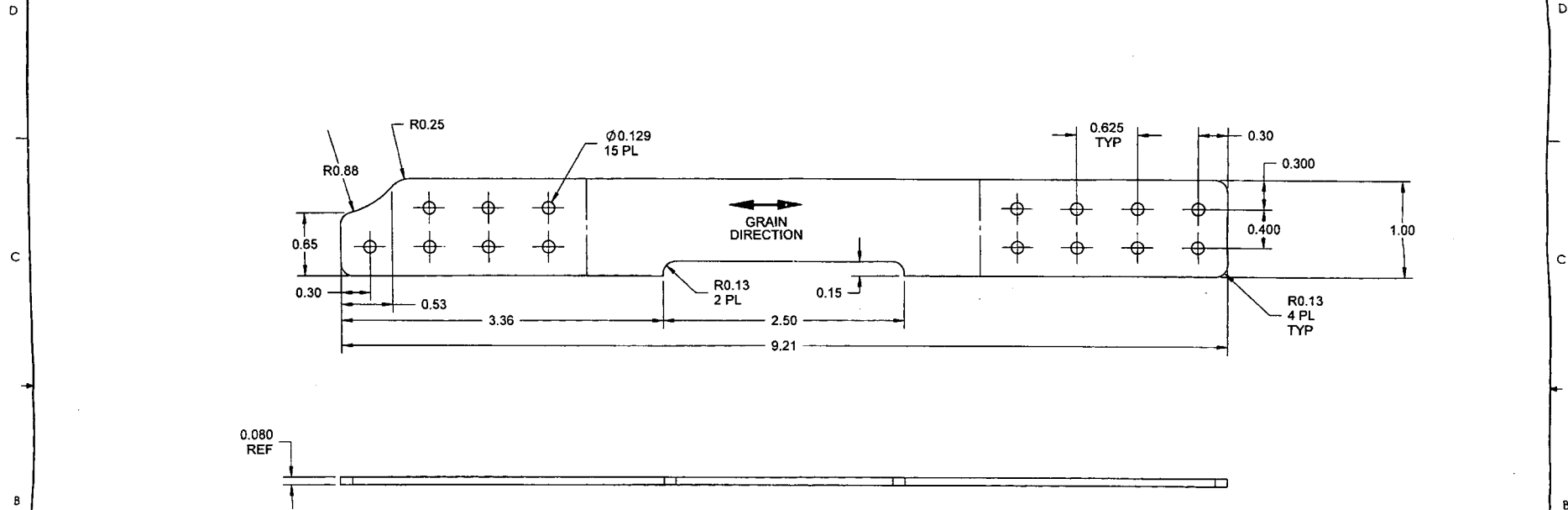
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**NOTE:** Date & initial all entries

8 7 6 5 4 3 2 1



**D3294-5F DOUBLER FLAT PATTERN**



**RELEASED**  
09/04/07

**NOTES:**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.080 THICK PER AMS-QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.080)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.07 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. <b>D3294</b>	REV. C
MFG. APPR.			SHEET 6 OF 6
APPROVED		TITLE <b>BRACKET</b>	SCALE
DE APPR.			NTS
DATE	<b>09.03.24</b>	<small>COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries